

Work Order ID 129485

129485

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February-12-15 7:57:30 AM

Item ID: D5190-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Armrest Fitting
 Start Date: 2/12/15 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 2/13/15 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <i>W/A 002</i>	0.00							
150						<i>8</i>	<i>2</i>	<i>15773</i>	
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									<i>15/2/17</i>
QC	Memo	0.00							
Quality Control									

Dis-2-13

Picklist Print

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Work Order ID: 129485

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Parent Item: D5190-1

D5190-1

Parent Item Name: Armrest Fitting

Start Date: 2/12/15

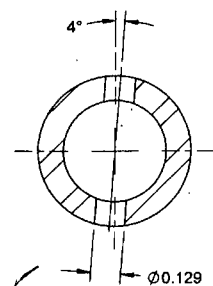
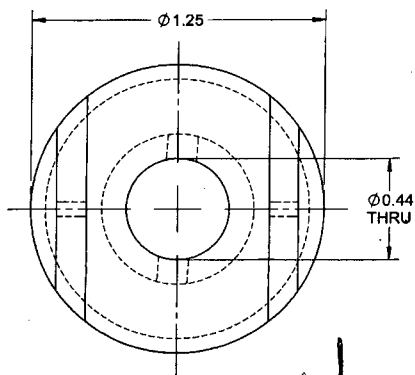
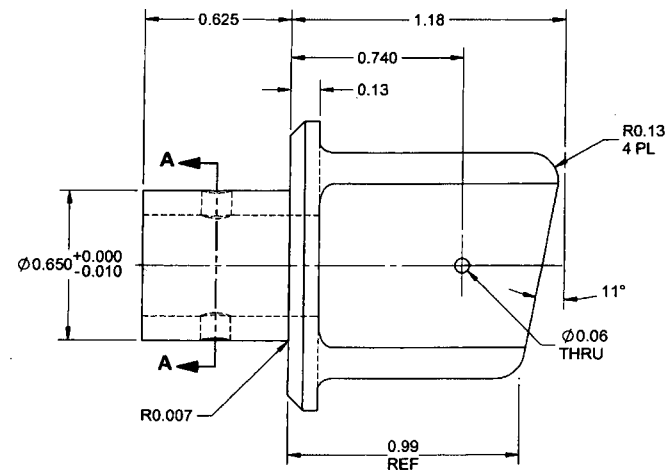
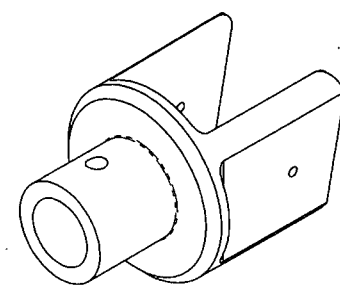
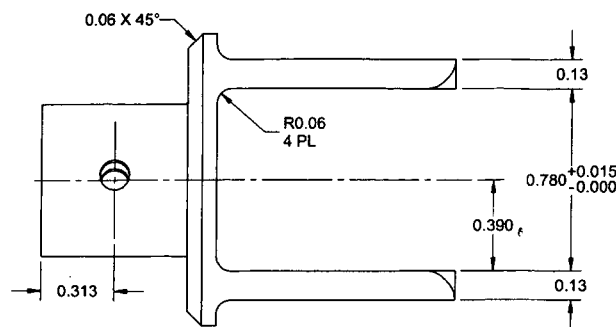
Required Date: 2/13/15

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 14.11.27 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NR1.250		Purchased		No			f	8.2500		2			
M4130NR1 250									**	<u>OK. 15.02.13</u>			
4130N ROUND BAR 1.250													
					<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>		
					MAT033			8.25					
					111874			8.25			<u>2 ft</u>		



W/O 179485

SECTION A-A

D5190-1 ARMREST FITTING

NOTES:

- 1) MATERIAL: AISI 4130N ROUND BAR
PER MIL-S-6758 OR AMS 6348/6370/6528
REF M4130N-R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.13 lbs

RELEASED

2015 FEB 04

EN 15-522 *9*

APPROVED

A		NEW ISSUE		AJS	14.11.19
REV.	DESCRIPTION			BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	AJS			SHEET 1 OF 2	
CHECKED	AP	DRAWING NO.		SCALE	
MFG. APPR.	JLM	D5190		NTS	
APPROVED	HS	TITLE			
DE APPR.	DS	ARMREST MACHINED PARTS			
DATE		14.11.19		COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

DART AEROSPACE LTD		Work Order: 129485
Description: ARM REST FITTING.		Part Number: 5190-1
Inspection Dwg: 5190	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.13	$\pm .030$	.122	✓		DR16	8" VERN
.780	$\pm .015 - .000$	.786	✓		PIN GAUGE	
.390	$\pm .010$	.390	✓		DR16	8" VERN
.313	$\pm .010$	.3125	✓		"	"
.625	$\pm .010$	.625	✓		"	"
.740	$\pm .010$	.739	✓		"	"
.13	$\pm .030$	.128	✓		"	"
Ø.650	$\pm .000 - .010$	.646	✓		"	"
Ø.06	$\pm .004 - .001$	.060	✓		"	"
Ø1.25	$\pm .030$	1.240	✓		"	"
Ø.44	$\pm .006 - .000$	.443	✓		"	"
Ø.129	$\pm .005 - .000$	.130	✓		"	"
4°	$\pm 1/2°$	40	✓		PROTRACTOR	

Measured by: 37 9-89		Audited by: AS DAS 08 9-89	Preliminary Approval:
Date: 15.02.13		Date: 15/02/13	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

A 10.04.15